

Date: Thursday, 5/3/2007 11:30:14 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 32166		
Estimate Number	: 10531		
P.O. Number	: <i>N/A</i>	Part Number	: D2572
This Issue	: 5/3/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 32077	Drawing Revision	: E
		Material	: <i>N/A</i>
		Due Date	: 5/22/2007
Written By	: <i>[Signature]</i>	Qty:	12 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: 1 02-10-02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: *B 25350*

ml 07/06/06

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. *B 32166* Double check by: *[Signature]*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

ml 15 07/06/10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

ml 15 07/06/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 15 07/06/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: PP Date: 07/06/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:30:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 32166

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.06.12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Handwritten initials

07.06.12 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 104 144

BR/M-1/07-06-18

(13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Handwritten initials

07/06/18 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten signature and date 07/06/18 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/19

Job Completion



Handwritten date 07-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32166
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.747	1.749		
C	3.495	3.505		3.497	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.747	1.747	1.749		
E	7.990	8.010		7.999	8.001	8.001	8.001		
F	0.490	0.510		0.496	0.495	0.491	0.495		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.498	0.499	0.500		
J	1.174	1.184		1.175	1.177	1.175	1.178		
K	0.558	0.578		0.565	0.565	0.565	0.571		
L	1.174	1.184		1.175	1.177	1.175	1.178		
M	1.490	1.500		1.492	1.494	1.492	1.495		
N	2.495	2.505		2.495	2.497	2.496	2.500		
O	3.869	3.879		3.871	3.871	3.873	3.872		
P	0.115	0.135		0.125	0.125	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.249	0.249		
S	0.115	0.135		0.123	0.129	0.127	0.130		
T	0.178	0.198		0.188	0.188	0.188	0.198		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.236	0.235	0.237	0.239		
W	0.115	0.135		0.127	0.130	0.131	0.135		
X	0.307	0.312		0.310	0.309	0.310	0.307		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.367	0.367	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.628	0.626	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.246	0.247	0.249		
AE	1.375	1.395		1.386	1.385	1.382	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.248	0.248	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: Er	Audited by: 02.06.12
Date: 07/06/08	Date: SN

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	32166
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.748	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.506	3.499	3.500		
D	1.745	1.755		1.748	1.749	1.749	1.749		
E	7.990	8.010		8.002	8.002	7.999	8.000		
F	0.490	0.510		0.501	0.503	0.503	0.503		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.501	0.500	0.500		
J	1.174	1.184		1.179	1.178	1.179	1.179		
K	0.558	0.578		0.569	0.576	0.569	0.569		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.490	1.500		1.494	1.498	1.495	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.125	0.125	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.248	0.249		
S	0.115	0.135		0.131	0.130	0.130	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.966		
V	0.230	0.250		0.240	0.246	0.241	0.236		
W	0.115	0.135		0.133	0.133	0.134	0.136		
X	0.307	0.312		0.309	0.309	0.309	0.308		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.370	0.365	0.367	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.630	0.630	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.257	0.247		
AE	1.375	1.395		1.385	1.386	1.384	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.250	0.249	0.257	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SM
Date:	07/06/09

Audited by:	SD
Date:	07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	32166
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.499	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.748		
E	7.990	8.010		7.999	8.000	8.001	8.002		
F	0.490	0.510		0.501	0.502	0.503	0.502		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.501	0.501	0.500	0.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.569	0.570	0.570	0.571		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.493	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.872		
P	0.115	0.135		0.125	0.125	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.250		
S	0.115	0.135		0.128	0.125	0.123	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.966		
V	0.230	0.250		0.234	0.236	0.235	0.235		
W	0.115	0.135		0.133	0.134	0.134	0.131		
X	0.307	0.312		0.310	0.309	0.309	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.360	0.357		
AA	0.470	0.530		0.500	0.500	0.500	0.506		
AB	0.615	0.635		0.630	0.630	0.630	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.247	0.246		
AE	1.375	1.395		1.389	1.386	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.260	0.260	0.260		
AH	0.240	0.260		0.246	0.246	0.247	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

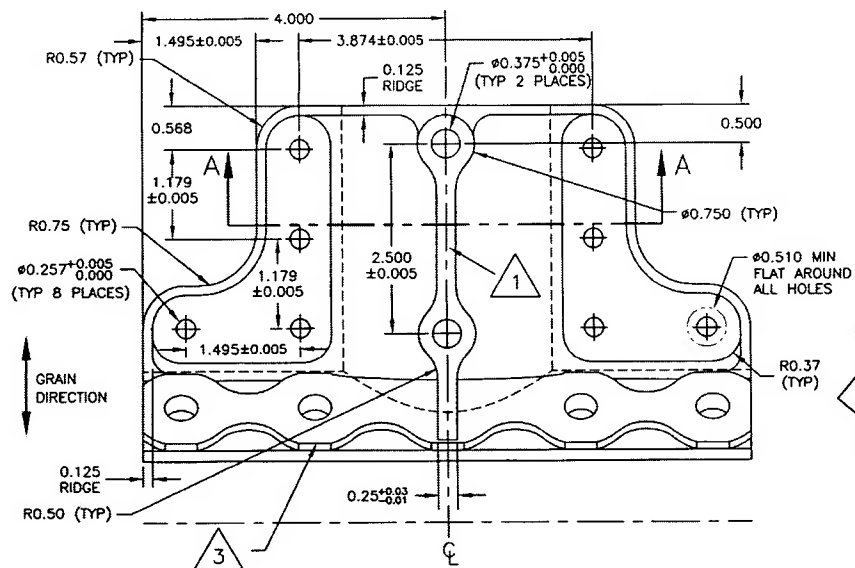
Measured by:	Amk
Date:	07/06/10

Audited by:	SD
Date:	07.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

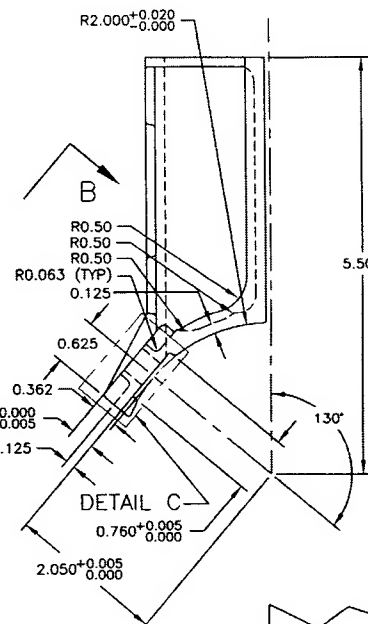
05.12.06



NOTES

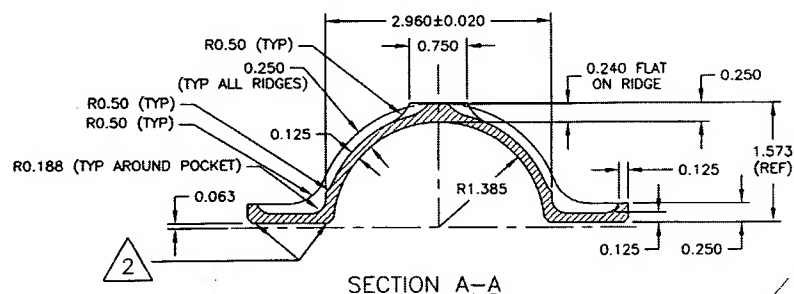
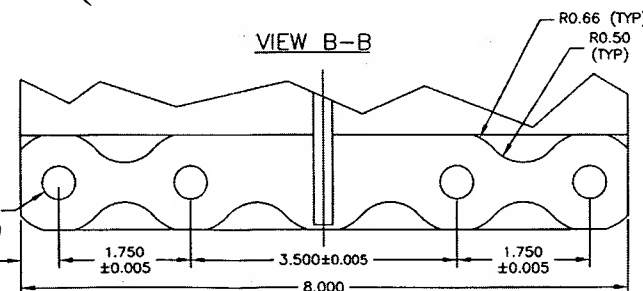
MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 3 CHAMFER 0.063 x 45° ALL AROUND
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C

VIEW B-B



SECTION A-A

DETAIL C
 SCALE 2:1

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE
		DART AEROSPACE LTD. HARVEYSHURRY, ONTARIO, CANADA
		DRAWING NO. D2572
		REV. E
		SHEET 1 OF 1
		SCALE 2:3

NO. 30166
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

